



A complete listing of all claims follows:

1. (Canceled) [A one piece chassis comprising:  
one piece of metal formed to include;  
a channel having a top, a bottom and a pair of sides;  
a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear; and  
a plurality of holes positioned in said pair of sides and adapted to receive axles for skate wheels; and  
predetermined regions of said one piece of metal later formed to include coined spacers surrounding each of said plurality of holes.]
2. (Canceled) [The chassis recited in claim 1 further including flat, annular surfaces on said coined spacers.]
3. (Canceled) [The chassis recited in claim 1 wherein said sides are substantially parallel to each other.]
4. (Canceled) [The chassis recited in claim 1 wherein said sides are inclined toward each other adjacent said top.]
5. (Canceled) [The chassis recited in claim 1 further including;  
at least one support brace extending from at least one of said sides, attached to the other one of said sides, and adapted to provide rigidity to said chassis.]
6. (Canceled) [The chassis recited in claim 1 further including at least one embossment in at least one of said sides.]
7. (Canceled) [The chassis recited in claim 1 further including at least one gusset formed between each flange and the associated one of said sides.]

8. (Canceled) [An in-line skate having a chassis formed from a single piece of metal comprising:

a chassis having a top portion, a bottom portion and two sides extending in a length direction;

footwear mounted to the top portion of the chassis;

a plurality of apertures formed and positioned in the bottom portion of the chassis along its length direction;

projections coined from said bottom portion of said single piece of metal surrounding said apertures and that extend from each side of the chassis toward the opposite side of the chassis; and

a plurality of wheels and axles rotatably mounted in the apertures and spaced between the two sides of the chassis by the projections.]

9. (Canceled) [An in-line skate chassis formed from a single piece of metal comprising:

a pair of sides including a first side, and a second side rigidly positioned substantially parallel to the first side;

a first plurality of apertures formed in the first side and a second plurality of apertures formed in the second side;

a first plurality of spacers coined from the first side and extending from the first side toward the second side; and

a second plurality of spacers coined from the second side and extending from the second side toward the first side.]

10. (Canceled) [The in-line skate of claim 9 further including at least one embossment in at least one of said sides.]

11. (Canceled) [An in-line skate comprising:

a chassis, formed from a single piece of metal, a plurality of wheels and axles rotatably mounted to a bottom part of the chassis, and footwear mounted on a top part of the chassis;

the chassis including a first side extending along a first direction and a second side extending in a direction substantially parallel to the first;

the first side including a plurality of first side holes formed in its bottom part;

said first side holes being surrounded by a plurality of spacers coined from the first side and extending in a direction toward the second side;

the second side including a plurality of second side holes formed in its bottom part;

said second side holes being surrounded by a plurality of spacers coined from the second side and extending in a direction toward the first side;

said axles extending through said holes in said first side and said second side; and

said wheels mounted on said axles and spaced between said sides by said spacers.]

12. (Canceled) [The in-line skate of claim 11 further including at least one embossment in the first side; and at least one embossment in the second side.]

13. (Canceled) [A method of making an in-line skate comprising:  
providing a single piece of metal suitable for forming;

forming said piece of metal into a skate chassis having a top portion, a bottom portion and two sides extending in a length direction;

forming a plurality of apertures in the bottom portion of the chassis along its length direction;

coining a plurality of annular projections from said piece of metal in areas surrounding said apertures to form a plurality of spacers extending from each side of the chassis toward the opposite side of the chassis;

rotatably mounting a plurality of wheels on axles extending through the apertures;  
and

mounting footwear to the top portion of the chassis.]

14. (Canceled) [An in-line skate chassis comprising;  
a channel having a top, a bottom and a pair of sides;

a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear; and

a plurality of holes positioned in said pair of sides and adapted to receive axles for skate wheels; and

predetermined regions of said sides later formed to include coined spacers surrounding each of said plurality of holes.]

15. (Canceled) [The chassis recited in claim 14 further including flat, annular surfaces on said coined spacers.]

16. (Canceled) [The chassis recited in claim 14 wherein said sides are substantially parallel to each other.]

17. (Canceled) [The chassis recited in claim 14 wherein said sides are inclined toward each adjacent said top.]

18. (Canceled) [The chassis recited in claim 14 further including:  
at least one support brace extending from at least one of said sides, attached to the other one of said sides, and adapted to provide rigidity to said chassis.]

19. (Canceled) [The chassis recited in claim 14 further including at least one embossment in at least one of said sides.]

20. (Canceled) [The chassis recited in claim 14 further including at least one gusset formed between each flange and the associated one of said sides.]

21. (Canceled) [An in-line skate having a chassis formed from metal comprising:  
the chassis having a top portion, a bottom portion and two sides extending in a length direction;  
footwear mounted to the top portion of the chassis;

a plurality of apertures formed and positioned in the bottom portion of the chassis along its length direction;

projections coined from said bottom portion of said chassis surrounding said apertures and that extend from each side of the chassis toward the opposite side of the chassis; and

a plurality of wheels and axles rotatably mounted in the apertures and spaced between the two sides of the chassis by the projections.]

22. (Canceled) [An in-line skate chassis formed from metal comprising:

a pair of sides including a first side, and a second side rigidly positioned substantially parallel to the first side;

a first plurality of apertures formed in the first side and a second plurality of apertures formed in the second side;

a plurality of spacers coined from the second side and extending from the second side toward the first side.]

23. (Canceled) [The in-line skate chassis of claim 22 further including at least one embossment in at least one of said sides.]

24. (Canceled) [An in-line skate comprising:

a chassis formed from metal, a plurality of wheels and axles rotatably mounted to a bottom part of the chassis, and footwear mounted on a top part of the chassis;

the chassis including a first side extending along a first direction and a second side extending in a direction substantially parallel to the first;

the first side including a plurality of first side holes formed in its bottom part;

said first side holes being surrounded by a plurality of spacers coined from the first side and extending in a direction toward the second side;

the second side including a plurality of second side holes formed in its bottom part;

said second side holes being surrounded by a plurality of spacers coined from the second side and extending in a direction toward the first side;

said axles extending through said holes in said first side and said second side; and  
said wheels mounted on said axles and spaced between said sides by said  
spacers.]

25. (Canceled) [The in-line skate of claim 24 further including:  
at least one embossment in the first side; and  
at least one embossment in the second side.]

26. (Canceled) [A method of making an in-line skate comprising:  
providing a metal skate chassis having a top portion, a bottom portion and two  
sides extending in a length direction;  
forming a plurality of apertures in the bottom portion of the chassis along its  
length direction;  
coining a plurality of annular projections from said chassis in areas surrounding  
said apertures to form a plurality of spacers extending from each side of the chassis  
toward the opposite side of the chassis;  
rotatably mounting a plurality of wheels on axles extending through the apertures;  
and  
mounting footwear to the top portion of the chassis.]

27. (Canceled) [A method of making an in-line skate comprising:  
providing metal suitable for forming;  
forming said metal into a skate chassis having a top portion, a bottom portion and  
two sides extending in a length direction;  
forming a plurality of apertures in the bottom portion of the chassis along its  
length direction;  
coining a plurality of annular projections from said chassis in areas surrounding  
said apertures to form a plurality of spacers extending from each side of the chassis  
toward the opposite side of the chassis;  
rotatably mounting a plurality of wheels on axles extending through the apertures;  
and

mounting footwear to the top portion of the chassis.]

28. (Canceled) [An in-line skate chassis comprising:
- a channel having a top, a bottom and a pair of sidewalls each having at least one surface;
  - a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear;
  - a plurality of holes positioned in said pair of sidewalls and adapted to receive axles for skate wheels; and
  - short cylinders formed from said holes and extending from the surfaces of said sidewalls.]

29. (Canceled) [An in-line skate having a chassis formed from metal comprising:
- a chassis having a top portion, a bottom portion and two sidewalls extending in a length direction;
  - footwear mounted to the top portion of the chassis;
  - a plurality of apertures formed and positioned in the bottom portion of the chassis along its length direction;
  - short cylinders coined from said apertures and extending from the surface of said chassis; and
  - a plurality of wheels and axles rotatably mounted in the apertures and supported by said sidewalls at the location of said apertures.]

30. (Canceled) [An in-line skate chassis formed from metal comprising:
- a pair of sides including a first side, and a second side rigidly positioned substantially parallel to the first side;
  - a first plurality of apertures formed in the first side and a second plurality of apertures formed in the second side;
  - a first plurality of short cylinders coined from the region adjacent each said apertures and extending from the first side toward the second side; and

a second plurality of short cylinders coined from the region adjacent each said aperture and extending from the second side toward the first side.]

31. (Canceled) [A method of making an in-line skate comprising:  
providing a metal skate chassis having a top portion, a bottom portion and two sides extending in a length direction;  
forming a plurality of apertures in the bottom portion of the chassis along its length direction;  
coining a plurality of short cylinders that extend from the surface of the chassis;  
rotatably mounting a plurality of wheels on axles extending through the apertures;  
and  
mounting footwear to the top portion of the chassis.]

32. (Canceled) [An in-line skate including an aluminum chassis, wheels mounted on axles, the axles rotatably mounted to the chassis through holes in the chassis and a shoe or boot attached to chassis, the improvement comprising:  
coined spacers surrounding the holes.]

33. (Canceled) [An in-line skate having an aluminum chassis and coined spacers formed in the chassis.]

34. (Canceled) [A method of making an in-line skate including providing an aluminum chassis, providing and attaching a shoe or boot to the chassis and providing a plurality of wheels mounted on axles extending through holes in the chassis, the improvement comprising:  
providing spacers in the aluminum chassis by coining annular projections from the aluminum in areas surrounding the holes in the chassis.]

35. (Canceled) [An improved method of making an aluminum chassis in-line skate, the improvement comprising:  
forming holes in the chassis through which axles may be positioned; and



coining annular projections from the aluminum in areas adjacent the holes in the chassis.]

36. (Canceled) [An improved method of making an aluminum chassis in-line skate, the improvement comprising:

forming holes in the chassis through which axles may be positioned; and  
extruding annular projections from the aluminum in areas adjacent the holes in the chassis.]

37. (Canceled) [A method of making an in-line skate comprising:

providing a first side of an aluminum chassis;  
providing a second side of an aluminum chassis;  
forming a plurality of axle holes in the first side;  
forming a plurality of axle holes in the second side;  
providing a plurality of projections in the first side by extruding from the first side aluminum adjacent the axles holes in the first side;  
providing a plurality of projections in the second side by extruding from the second side aluminum adjacent the axles holes in the first side;  
providing on the first side at least one flange adapted for attachment to a portion of a shoe or boot bottom;  
attaching the shoe or boot to the first side and to the second side; and  
providing a plurality of wheels rotatably mounted through pairs of the axle holes.

38. (Currently Amended) A metal in-line skate chassis comprising:

a first metal side having an interior surface and an exterior surface;  
a second metal side having an interior surface and an exterior surface;  
a plurality of holes formed in the first metal side;  
a plurality of holes formed in the second metal side;  
spacers formed when areas are countersunk or counterpressed by coining on the exterior surface of the first metal side from metal adjacent the holes in the first metal side;

spacers formed when areas are countersunk or counterpressed by coining on the exterior surface of the second metal side from metal adjacent the holes in the second metal side;

the spacers formed when areas are countersunk or counterpressed by coining forming truncated cylinders and extending from the interior side of the first metal side and from the interior surface of the second metal side.

39. (Currently amended) An in-line skate including a metal chassis, wheels mounted on axles that extend through holes in the chassis, and spacers positioned adjacent the holes, the improvement comprising:

the spacers being truncated cylinders formed when areas are countersunk or counterpressed by coining on the chassis.

40. (Currently amended) An in-line skate including a metal chassis, wheels mounted on axles that extend through holes in the chassis and spacers adjacent the holes, the improvement comprising:

the spacers formed when areas are countersunk or counterpressed by coining countersinking; at a convenient time in the process, material adjacent the holes into short, truncated cylinders or cones that extend from the surface of the metal chassis.

41. (Currently amended) A process of manufacturing an in-line skate having a metal chassis, the improvement comprising:

at a convenient time in the process, forming short, truncated cylinders that extend from the surface of one side of the metal chassis and a countersunk or counterpressed configuration adapted to accommodate the head of a screw or axle.

42. (Currently amended) A process of manufacturing an in-line skate having a metal chassis and a plurality of holes in the chassis for supporting wheel axles, the improvement comprising:

at a convenient time in the process after the holes have been made, countersinking spacers formed when areas are countersunk or counterpressed by coining that extend

from a first surface of the chassis and leaving on a second, opposite surface of the chassis a configuration that will accommodate a ~~flat head~~ screw or axle.

43. (Currently amended) An in-line skate chassis comprising:

a channel having a top, a bottom and a pair of sidewalls each having an inner surface and an exterior surface;

a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear;

a plurality of holes positioned in said pair of sidewalls and adapted to receive axles for skate wheels; and

short cylinders formed when areas are countersunk or counterpressed by coining from material adjacent said holes and extending from each interior surface of said pair of sidewalls.

44. (New) A one piece chassis comprising:

one piece of metal formed to include;

a channel having a top, a bottom and a pair of sides;

a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear; and

a plurality of holes positioned in said pair of sides and adapted to receives axles for skate wheels; and

predetermined regions of said one piece of metal later formed to include coined spacers surrounding each of said plurality of holes.

45. (New) The chassis recited in claim 44 further including flat, annular surfaces on said coined spacers.

46. (New) The chassis recited in claim 44 further wherein said sides are substantially parallel to one another.

47. (New) The chassis recited in claim 44 wherein said sides are inclined toward each other adjacent said top.

48. (New) The chassis recited in claim 44 further including;  
at least one support brace extending from at least one of said sides, attached to the other one of said sides, and adapted to provide rigidity to said chassis.

49. (New) The chassis recited in claim 44 further including at least one embossment in at least one of said sides.

50. (New) The chassis recited in claim 44 further including at least one gusset formed between each flange and the associated one of each sides.

51. (New) An in-line skate having a chassis formed from a single piece of metal comprising:

- a chassis having a top portion, a bottom portion and two sides extending in a length direction;

- footwear mounted to the top portion of the chassis;

- a plurality of apertures formed and positioned in the bottom portion of the chassis along its length direction;

- projections coined from said bottom portion of said single piece of metal surrounding said apertures and that extend from each side of the chassis toward the opposite side of the chassis; and

- a plurality of wheels and axles rotatably mounted in the apertures and spaced between the two sides of the chassis by the projections.

52. (New) An in-line skate chassis formed from a single piece of metal comprising:

- a pair of sides including a first side, and a second side rigidly positioned substantially parallel to the first side;

- a first plurality of apertures formed in the first side and a second plurality of apertures formed in the second side;

a first plurality of spacers coined from the first side and extending from the first side toward the second side; and  
a second plurality of spacers coined from the second side and extending from the second side toward the first side.

53. (New) The in-line skate chassis of claim 52 further including at least one embossment in at least one of said sides.

54. (New) An in-line skate comprising:

a chassis, formed from a single piece of metal, a plurality of wheels and axles rotatably mounted to a bottom part of the chassis, and footwear mounted on a top part of the chassis;

the chassis including a first side extending along a first direction and a second side extending in a direction substantially parallel to the first;

the first side including a plurality of first side holes formed in its bottom part;

said first side holes being surrounded by a plurality of spacers coined from the first side and extending in a direction toward the second side;

the second side including a plurality of second side holes formed in its bottom part;

said second side holes being surrounded by a plurality of spacers coined from the second side and extending in a direction toward the first side;

said axles extending through said holes in said first side and said second side; and  
said wheels mounted on said axles and spaced between said sides by said spacers.

55. (New) The in-line skate of claim 54 further including at least one embossment in the first side; and at least one embossment in the second side.

56. (New) A method of making an in-line skate comprising:  
providing a single piece of metal suitable for forming;

forming said piece of metal into a skate chassis having a top portion, a bottom portion and two sides extending in a length direction;

forming a plurality of apertures in the bottom portion of the chassis along its length direction;

coining a plurality of annular projections from said piece of metal in areas surrounding said apertures to form a plurality of spacers extending from each side of the chassis toward the opposite side of the chassis;

rotatably mounting a plurality of wheels on axles extending through the apertures;  
and

mounting footwear to the top portion of the chassis.

57. (New) A one-piece metal in-line skate chassis comprising:

a first metal side having an interior surface and an exterior surface;

a second metal side having an interior surface and an exterior surface;

a plurality of holes formed in the first metal side;

a plurality of holes formed in the second metal side;

spacers formed when areas are countersunk or counterpressed by coining on the exterior surface of the first metal side from metal adjacent the holes in the first metal side;

spacers formed when areas are countersunk or counterpressed by coining on the exterior surface of the second metal side from metal adjacent the holes in the second metal side;

the spacers formed when areas are countersunk or counterpressed by coining forming truncated cylinders and extending from the interior side of the first metal side and from the interior surface of the second metal side.

58. (New) An in-line skate including a one-piece metal chassis, wheels mounted on axles that extend through holes in the chassis, and spacers positioned adjacent the holes, the improvement comprising:

the spacers being truncated cylinders formed when areas are countersunk or counterpressed by coining on the chassis.

59. (New) An in-line skate including a one-piece metal chassis, wheels mounted on axles that extend through holes in the chassis and spacers adjacent the holes, the improvement comprising:

the spacers formed when areas are countersunk or counterpressed by coining countersinking-material adjacent the holes into short, truncated cylinders or cones that extend from the surface of the metal chassis.

60. (New) A process of manufacturing an in-line skate having a one-piece metal chassis, the improvement comprising:

forming short, truncated cylinders that extend from the surface of one side of the metal chassis and a countersunk or counterpressed configuration adapted to accommodate a screw or axle.

61. (New) A process of manufacturing an in-line skate having a one-piece metal chassis and a plurality of holes in the chassis for supporting wheel axles, the improvement comprising:

spacers formed when areas are countersunk or counterpressed by coining that extend from a first surface of the chassis and leaving on a second, opposite surface of the chassis a configuration that will accommodate a screw or axle.

62. (New) A one-piece in-line skate chassis comprising:

a channel having a top, a bottom and a pair of sidewalls each having an inner surface and an exterior surface;

a plurality of flanges positioned at the top of said channel and adapted for attachment of footwear;

a plurality of holes positioned in said pair of sidewalls and adapted to receive axles for skate wheels; and

short cylinders formed when areas are countersunk or counterpressed by coining from material adjacent said holes and extending from each interior surface of said pair of sidewalls.